

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000235**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 17-Aug-2007**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** 0 / 0 **HSR's:** 0 / 0 **NCR's:** 0 / 2

Item	Title	Detail
1	Major component movement	Continued welding of 77m Tower Mock-up. Welding included tack welding skin plates C, D and E. Work was suspended (see below). Weld PQR HP2007149-1, welding is in progress.
2	Meetings attended	QA met with ABF at 1500 to discuss the schedule for tomorrow: Sand Blast 2 plates for the 89m and 1 plate for the 114m Tower Mock-up. Cut and bevel 1 plate the for 114m Tower Mock-up on Saturday and 1 plate for the 77m and 1 plate for the 114m Tower Mock-ups on Sunday. Welding of the PJP splice welds on the 77m Tower Mock-up skin plates will be based upon approval of the appropriate WPS. Additionally, ABF informed QA that the ABF Mock-ups were complete and that ZPMC would be submitting additional WQCP addendum for welder qualifications on site.
3	Key conversations	At the 1500 meeting, ABF gave QA the Tower Skin Plate PJP WPS to review. The joint detailed was a CJP (B-U3) instead of a PJP. It was also a FCAW WPS instead of a SAW WPS. QA asked ABF about this, they spoke with ZPMC and found out that joint detail was a mistake, but that ZPMC decided to perform FCAW on the root and SAW for the remaining passes. The Mock-up shop drawings detail a SAW weld for this joint. We discussed why ZPMC was changing the joint and if this was how they planned on welding in production. ZPMC informed QA and ABF that they plan to use SAW in production, but that since SAW PQR HP200748 was rejected earlier in the day due to error in the listed parameters, they decided to submit the FCAW procedure instead.

After ZPMC discussed this with ABF, they decided they would correct PQR HP200748 and submit a SAW PJP procedure. By this time it was after 4pm.

ABF informed ZPMC that they would not have people in on Saturday to review and submit the WPS to Caltrans, and that they would look at the WPS on Monday. ZPMC stated that they were done with the tack welding

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and would not be able to weld over the weekend without the SAW procedure. ABF informed QA that no welding would take place this weekend, and they would sort out the WPS and weld joint issues on Monday.

4 Other important observations

QA observed the machining of Calibration blocks for the Closed-rib UT procedure. QA expressed concerns with the method of machining ZPMC was using (wire band saw). ABF on-site QCM Nate Lindell shared QA's concerns regarding how accurate this method would be for producing the required 10, 20, 30 and 40% notches. Both QA and Mr. Lindell had expected the notches to be produced by EDM (electron discharge machining).

5 Quality Assurance Inspectors per shift

4 AM (Cuellar, Franco- 1st shift, Brannon- 2nd shift, Acuna- 3rd shift[cancelled])
0 PM

6 Logistics

The three shifts began this morning to cover 24 hours a day a ZPMC were cancelled due to the lack of the appropriate weld procedure.
QA (Brannon and McClary) had to take the 5pm ferry, get a ride from ABF to Seasons Villas, and take a taxi from there back to the Marriott.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
